

**Bench, shell and casting procedure, in particular for
engine cylinder heads**

ABSTRACT

This invention regards a bench, a shell and a casting
5 procedure, particularly for engine cylinder heads,
characterised by low-pressure casting, or the
introduction of molten metal from a furnace into a shell
positioned above it, exercising pressure on the surface
of the molten metal inside the same furnace, combined
10 with the free-fall feeding of the same shell.

Free-fall casting takes place with open risers created in
the shell, the latter being sealed at the top, at least
in line with these risers, by lids moved by a tilting arm
joined to the casting bench.